

Work Order ID 166248

Wednesday, September 13, 2017 11:34:43 A

166248

Page 1

Item ID: D2855-5 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Cap
 Start Date: 9/14/2017 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 9/19/2017 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: [Signature] Date: SEP 13 2017 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2855	C								

147 0.00
147
 Skidtubes
 Skidtubes
 Memo
 PULL FROM STOCK
 D2855-3 X10
 B: 153291 A/R m137133
 FILL HOLES AND GRIND

150 White Gloss(Ref:4.3.5.1) per OSI005 4.3-Alum 0.00
150
 Powdercoat
 Powder Coating
 Memo
 START TIME: 8:25
 OVEN TEMPERATURE: 320
 FINISH TIME: 8:45

36 34 33

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.10							
Quality Control									
170		0.00							
170	Small Fab								
Small Fab	Memo	0.45							
Small Fab	Install Insert as per Dwg D2855								
180	QC5- Inspect part completeness to step on W/O	0.00							
180									
QC	Memo	0.20							
Quality Control									

DAS
15
9-89(x10) 10 12/09/15
BEB.SEP 15 2017
10 SEP 12 2017
DAS
9
9-89

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Item ID: D2855-5 Accept ***N900040100*** Setup Start ***NS1***
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Item Name: Cap
Start Date: 9/14/2017 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 9/19/2017 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: <u>LG 001</u>	0.00				<u>10</u>	<u>0</u>		<u>JW</u>
190									
Packaging	Memo	0.10							
Packaging	LOCATION: <u>EP001</u>						<u>17-09-15</u>		
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	1.00							<u>17/9/19</u>
Quality Control									<u>AS</u>

SEP 18 2017

DAS
21
9-89

Picklist Print

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Page 1

Work Order ID: 166248

166248

Parent Item: D2855-5

D2855-5

Parent Item Name: Cap

Start Date: 9/14/2017

Required Date: 9/19/2017

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 17.05.10 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

ALS7-1032-225

AELS8-1032-225

Purchased

No

170

Each

116.0000

1

10

AI S7-1032-225

**

Insert

Location

Loc Qty

Loc Code

FG

116

118520

116

D2855-3

Manufactured

No

Each

74.0000

10

D2855-3

**

Cap

Location

Loc Qty

Loc Code

FP001

74

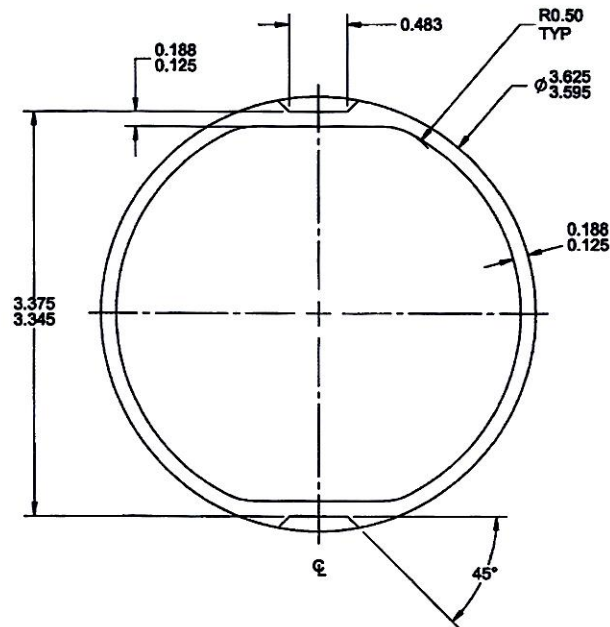
151614

2

153291

72

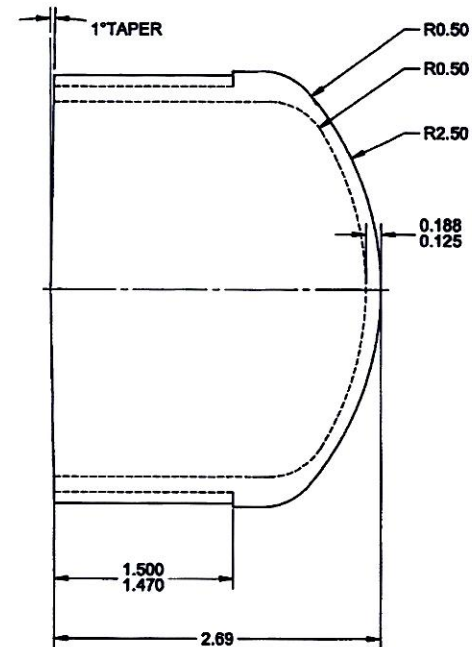
10



D2855C CASTING DETAIL CAP

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 166248

SEP 13 2017



- NOTES:
- 1) MATERIAL: CASTING ALUMINUM ALLOY A356.2 (F)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.62 lbs

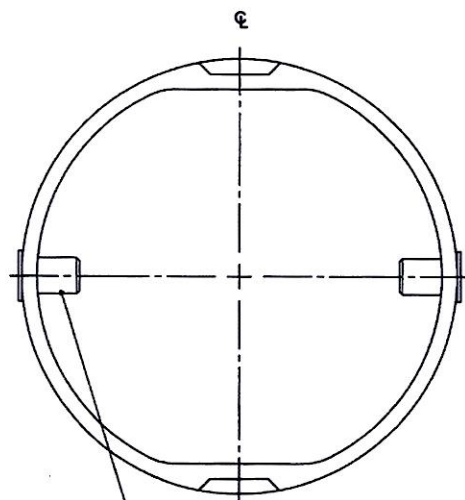
RELEASED
2017-05-08
ECN 17-519

APPROVED

C	ADDED D2855-5 (ZN C8-4)	WK	17.03.01
B	DRAWING UPDATED TO CURRENT STANDARDS. ADD D2855-3 & D2855C (ZN B8-1, A8-3)	RF	09.06.30
A	NEW ISSUE (WAS D2575 REV. E)	DS	06.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN	DS		
DRAWN	WK		
CHECKED	RF		
MFG. APPR.	JFS		
APPROVED	HS		
DE APPR.	DS		
DATE	17.03.01		

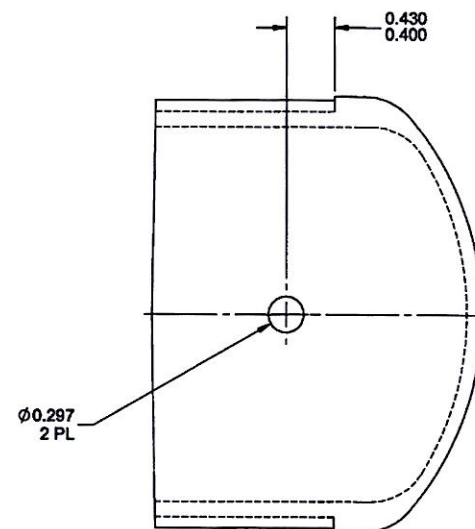
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D2855	REV. C
TITLE CAP	SHEET 1 OF 4
	SCALE NTS

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INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR
ALS7-1032-225, OR AKS4-1032-225) INSERT ON
INSIDE OF CAP (AFTER POWDER COAT)
2 PL

D2855 CAP
(MAKE FROM D2855C CASTING)



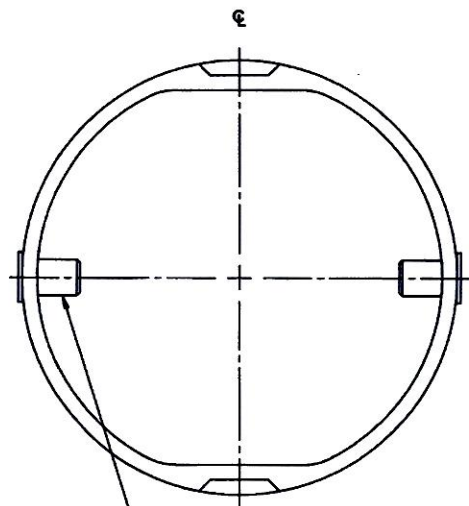
NOTES:

- 1) MATERIAL: MAKE FROM D2855C
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.63 lbs

RELEASED
2017-05-08

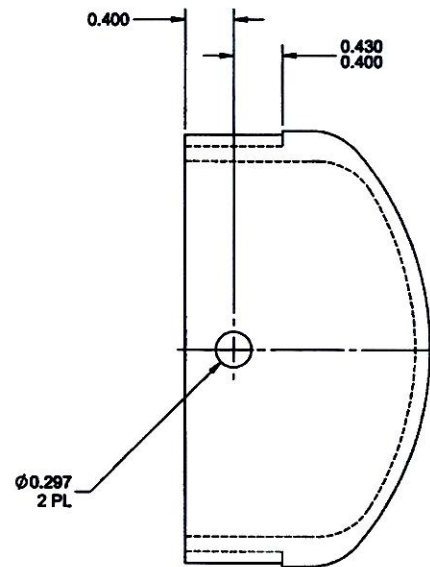
APPROVED

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	WK		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	JFS	D2855	SHEET 2 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CAP	NTS
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INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR
ALS7-1032-225, OR AKS4-1032-225) INSERT ON
INSIDE OF CAP (AFTER POWDER COAT)
2 PL

D2855-3 CAP
(MAKE FROM D2855C CASTING)



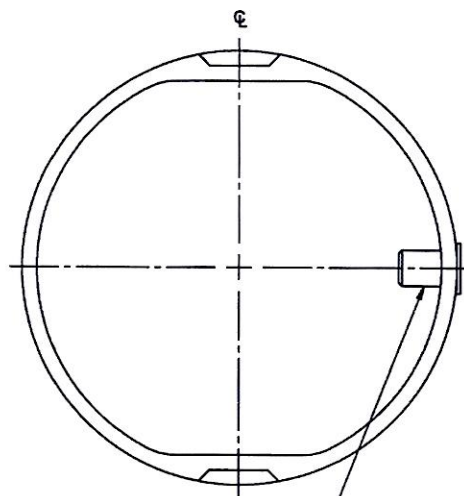
NOTES:

- 1) MATERIAL: MAKE FROM D2855C OR D2855
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.50 lbs

RELEASED
2017-05-08

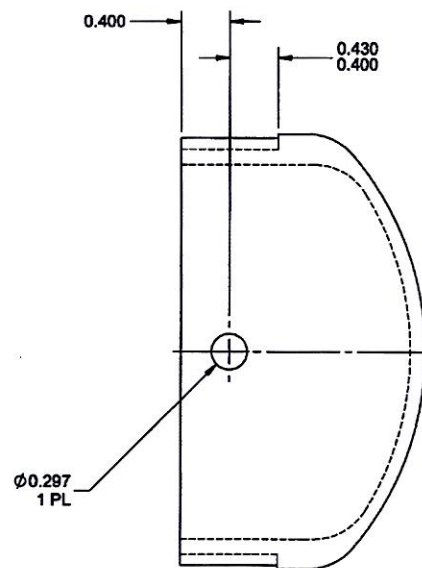
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DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	WK		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	JFS	D2855	SHEET 3 OF 4
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DE APPR.	DE	CAP	NTS
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INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR
ALS7-1032-225, OR AKS4-1032-225) INSERT ON
INSIDE OF CAP (AFTER POWDER COAT)
1 PL

D2855-5 CAP
(MAKE FROM D2855C CASTING)



NOTES:

- 1) MATERIAL: MAKE FROM D2855C
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.50 lbs

RELEASED
2017-05-08

APPROVED

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	WK	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	JFS	D2855	SHEET 4 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CAP	NTS
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